

# Work Order ID 52584

October 2, 2009 11:22:07 AM



Page 1

Item ID:	D3394-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Lug Assembly					
Start Date:	02/10/2009	Start Qty: 40.00		Cust Item ID:		
Required Date:	14/10/2009	Req'd Qty: 40.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>BS</u>	Date:	<u>09-10-2</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3394	Rev A								
100	BAND SAW	0.00							
	Bandsaw	0.00							
	Jeaspa Bandsaw								
	Memo								
	Cut Blank to .850"								
105	Outsource process - Machining	0.00							
<u>HAAS</u>									
110	Outsource process - Machining	0.00							
	Outsource5	0.00							
	Memo								
	Send Blanks To: Metec/Mast Precision								
	Machining <input type="checkbox"/> P/O: _____ <input type="checkbox"/> Machine D3394-1 as per Dwg D3394								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
	Packaging	0.00							
	Packaging								

*09/10/30*

*09/10/31*

*09/10/31*

*40 35 33*

*QC 2*

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Page 2

Item ID: D3394-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Lug Assembly

Start Date: 02/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 14/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

*09/11/24* *(33)*

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*09/11/24*

*(X33)* *0*

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME: *11:50AM* OVEN TEMPERATURE:  
FINISH TIME: *12:20PM* *320*

*09/11/25*

*(X33)* *0*

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Item ID:	D3394-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Lug Assembly					
Start Date:	02/10/2009	Start Qty: 40.00		Cost Item ID:		
Required Date:	14/10/2009	Req'd Qty: 40.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00	⇒ M. L. 09/11/26			(33X)			
QC Quality Control	Memo	0.00							
170 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3394								
									09/11/30 (33)
180 	QC5- Inspect part completeness to step on W/O	0.00	⇒ S. O. 11/30			count (X33) ✓			
QC Quality Control	Memo	0.00							

**Work Order ID 52584**

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Item ID: D3394-041  
Revision ID: A  
Item Name: Lug Assembly

Accept



Setup Start



Stop



Start Date: 02/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 14/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>474</u>	0.00							
	Packaging	0.00							
	Packaging								
200	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Quality Control								

9/11/30 (33x) sf

09/12/01

u 09-12-01

# Picklist Print

Page 1

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Work Order ID: 52584



Parent Item: D3394-041RevA



Parent Item Name: Lug Assembly

Start Date: 02/10/2009

Required Date: 14/10/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS35489-93		Purchased	No			100	Each	220.0000	80.0000			
------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



GROMMET

*LO 9/11/26*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 220

106168 29

111424 2

111477 89

112492 100

*M113288 (33x) 9/29/11/30*

D2423RevB1		Manufactured	No			110	f	672.6908	2.9474			
------------	--	--------------	----	--	--	-----	---	----------	--------	--	--	--



Lug Extrusion

*112492 34X*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 672.69078

43722 213.01468

44529 22.39

→ 45800 437.2861

*2.9474 9/2 09/10/30*

D3394-1PRevA		Purchased	No			170	Each	0.0000	40.0000			
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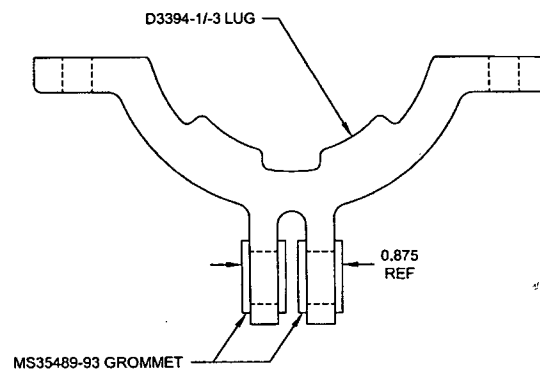
Lug

*[Handwritten signature and scribbles]*

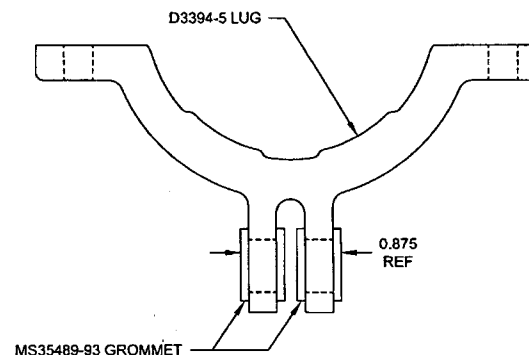


QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET

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D3394-041/-043 LUG ASSEMBLY



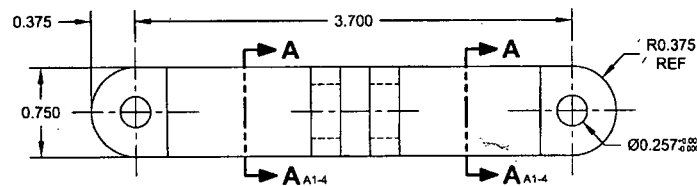
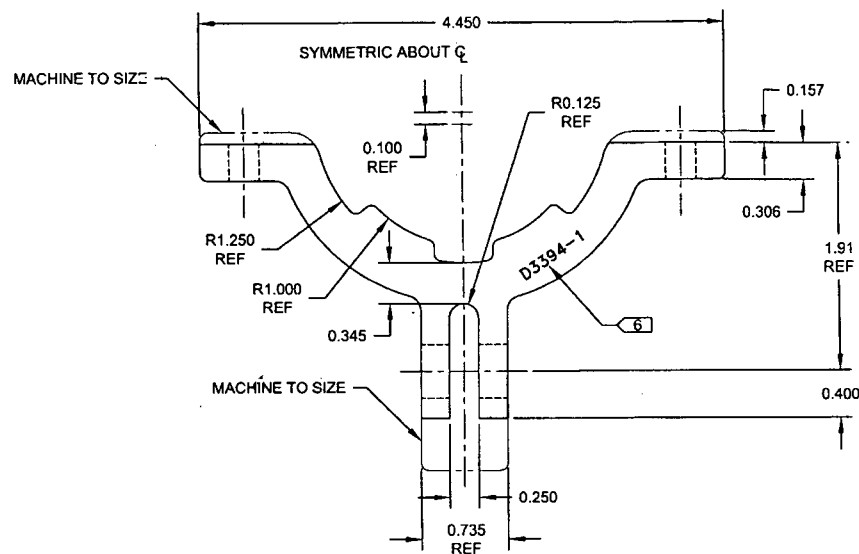
D3394-045 LUG ASSEMBLY

RELEASED  
09/04/02

**NOTES:**

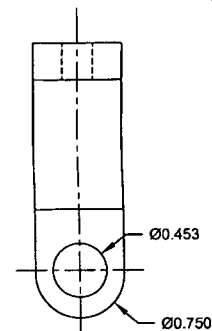
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

B	ADDED -045. SHT 4 ADDED FILLETS IN SECTION A-A. SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14
REV.	DESCRIPTION	BY	DATE
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D3394-1 LUG

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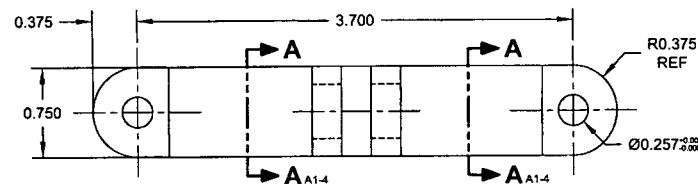
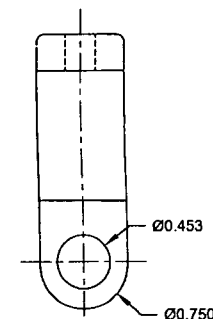
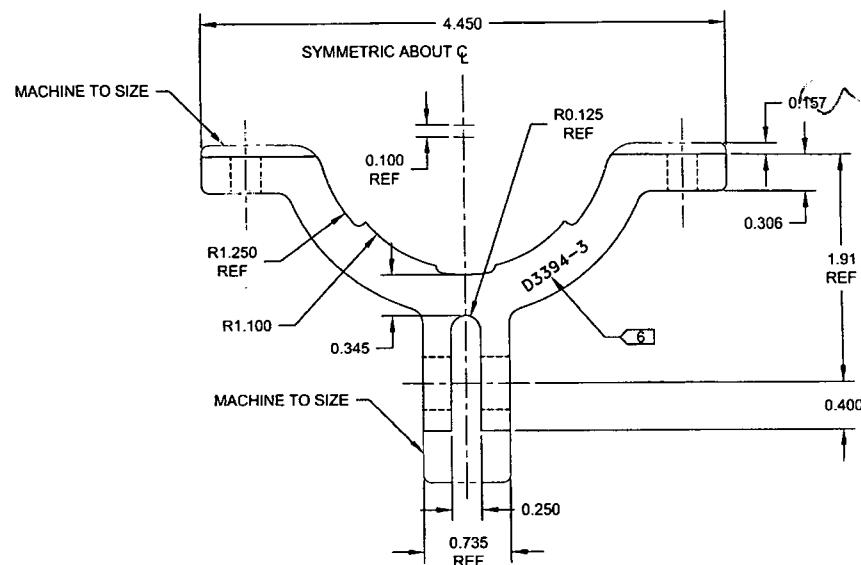
- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

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D3394-3 LUG

**NOTES:**

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

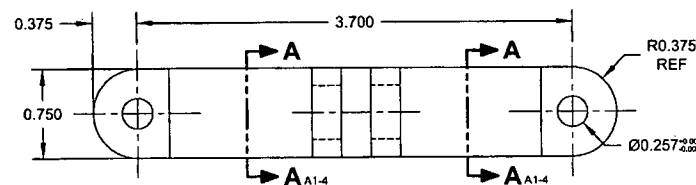
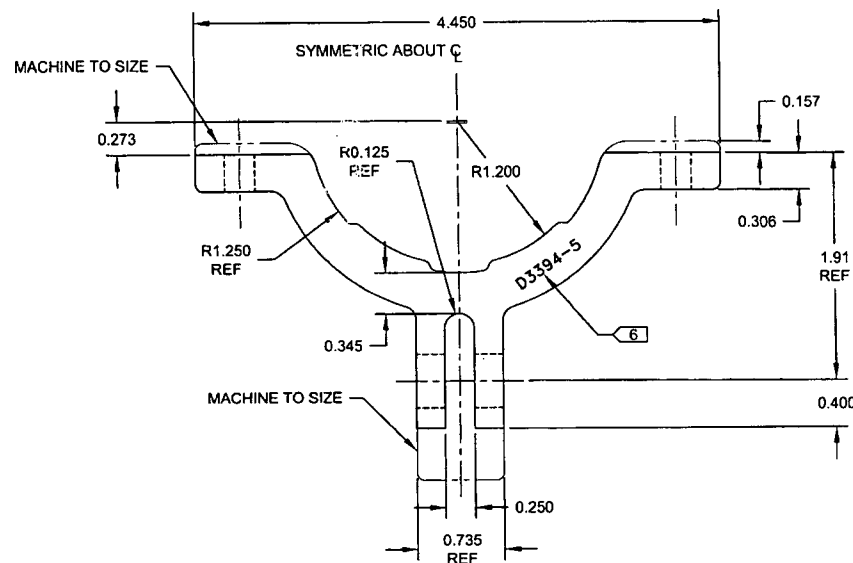
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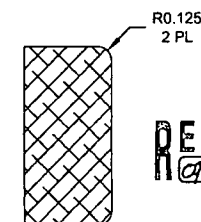
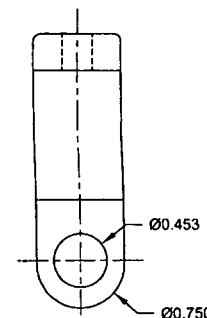
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*PL 09-10-2*



D3394-5 LUG



SECTION A-A

RELEASED  
*9/16/25 HP*

B5-2  
B4-2  
B5-3  
B4-3  
B5-4  
B4-4

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

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